

Work Order ID 149049

Tuesday, July 19, 2016 10:16:45 AM

149049

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D206-642-521PHI
 Revision ID: PRELIM
 Item Name: Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/19/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/27/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 19 2016 Tooling: Date:
 QC: 9-89 Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
IIN-D206-642	Q		DAS 8 9-89	JUL 26 2016			DAS 21 9-89	1607-23	

100 Document Control
 DOCUMENT CONTROL

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-642-521

CH0006

DAS 21 9-89

DAS 27 9-89

AUG 04 2016

110 Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS 28 9-89

JUL 27 2016

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.01

Quality Control

DAS 27 9-89

AUG 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
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Root Cause		FAULT CATEGORY																																																													
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Misidentified ☐	Past Due ☐																																																														

Work Order ID 149049***149049***

Page 2

Tuesday, July 19, 2016 10:16:45 AM

Item ID: D206-642-521PHI Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible
Start Date: 7/19/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/27/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-511 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

DAS 27 9-89
DAS 28 9-89
AUG 04 2016
DAS 21 9-89
AUG 05 2016

POSITIVE RECALL

EFFECTIVE 160722 AUTH 1
RELEASED 9-89 DATE 160805

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Tuesday, July 19, 2016 10:17:02 AM

Page 1

Work Order ID: 149049

149049

Parent Item: D206-642-521PHI

D206-642-521PHI

Parent Item Name: Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.23 NEW ISSUE LL VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5C15A		Purchased	No				Each	23.0000		1			DAS 28 9-89
AN5C15A									**				
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				over003				20					
				M135058				20					
				ST337				3					
				M130466				3					
D206-642-561PHI		Manufactured	No				Each	0.0000		1			DAS 28 9-89
D206-642-561PHI									**				
Replacement Skidtube,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible													
D206-648-013PHI		Manufactured	No				Each	0.0000		1			DAS 28 9-89
D206-648-013PHI									**				
Ground Handling Wheel Modification													
NAS1149C0532R		Purchased	No				Each	352.0000		8			DAS 28 9-89
NAS1149C0532R									**				
WASHER													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				60					
				116513				60					
				ST260a				200					
				m135056				200					
				ST266				92					
				m134756				92					
D2932-1PHI		Manufactured	No				Each	0.0000					DAS 28 9-89
D2932-1PHI									**				
Saddle LH Out, 206													

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐		☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator ☐		☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup ☐		☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier ☐		☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training ☐		☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing ☐		☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information ☐		☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing ☐		☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement ☐		☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER :							
Misidentified ☐	☐	Past Due ☐									

Picklist Print

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Work Order ID: 149049

149049

Parent Item: D206-642-521PHI

D206-642-521PHI

Parent Item Name: Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D2933-1PHI

Manufactured No

Each

0.0000

Start Qty: 1.00

Required Qty: 1.00

D2933-1PHI

Saddle LH In, 206 27

D2938-1PHI 9-89

Manufactured No

Each

0.0000

**

① X B147598 PC DAS 28 9-89

D2938-1PHI

Saddle LH Out, 206

D2939-1PHI

Manufactured No

Each

0.0000

**

① X B147550 PC DAS 28 9-89

D2939-1PHI

Saddle LH In, 206

AN3C41A

Purchased No

Each

302.0000

**

① X B147413 PC DAS 28 9-89

AN3C41A

Bolt

**

8 PC DAS 28 9-89

Location

Loc Qty

Loc Code

FG	10
122843	5
124975	1
m130081	4
OVER002	225
m132169	75
m132381	75
m132522	75
ST347	67
131651	67

~~JUL 27 2016~~

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

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Work Order ID: 149049

149049

Parent Item: D206-642-521PHI

D206-642-521PHI

Parent Item Name: Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D2652

Manufactured No

Each

Start Qty: 1.00
477.0000

Required Qty: 1.00

D2652

Bushing

**

16

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	45	
31985	45	
ST009	124	
147559	124	
ST012a	308	
145959	308	

Each

976.0000

**

20

DAS
28
9-89

MS21043-3

Purchased No

MS21043-3

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	11	
m130673	11	
GA	237	
m133990	237	
OVER007	400	
m135058	400	
ST302	142	
m134861	142	
ST304	106	
m131340	106	

20

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____					

Picklist Print

Tuesday, July 19, 2016 10:17:02 AM

Page 4

Work Order ID: 149049

149049

Parent Item: D206-642-521PHI

D206-642-521PHI

Parent Item Name: Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D3672-7

Manufactured No

Each

Start Qty: 1.00
803.0000

Required Qty: 1.00

D3672-7

Washer, Phenolic

**

24

PC
DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

40

129987

25

133986

15

ST049

263

142572

263

ST051A

500

147220

500

Each

116.0000

4

**

PC
DAS
28
9-89

AN5C11A

Purchased

No

AN5C11A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

4

103715

4

over003

40

M135058

40

ST338

72

M131305

22

M131624

50

4

JUL 27 2016

Tuesday, July 19, 2016 10:17:02 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Page 5

Work Order ID: 149049

149049

Parent Item: D206-642-521PHI

D206-642-521PHI

Parent Item Name: Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

AN4C6A

Purchased

No

Each

345.0000

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Bolt

**

12

PC DAS 28 9-89

Location

Loc Qty

Loc Code

FG	14
103344	4
121657	10
ST345	331
m134502	6
m134861	75
m134955	150
m135127	100

12

DAS 27 9-89

D3672-3

Manufactured

No

Each

717.0000

**

24

PC DAS 28 9-89

D3672-3

Washer, Phenolic

Location

Loc Qty

Loc Code

FG	100
133083	52
134449	48
FP001	213
132639	213
ST049	404
142571	13
146277	391

24

DAS 27 9-89

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Page 6

Work Order ID: 149049

149049

Parent Item: D206-642-521PHI

D206-642-521PHI

Parent Item Name: Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

NAS1149C0432R

Purchased

No

Each

977.0000

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

WASHER

**

24

P DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

GA	801
m125807	427
m134676	374
ST266	176
m134676	176

24

MS21043-4

Purchased

No

Each

753.0000

MS21043-4

Nut

**

12

P DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FG	40
104603	40
GA	17
m132803	17
OVER007	300
m134754	300
ST302	396
m134502	96
m134943	300

12

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER :																																																																							

Picklist Print

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Work Order ID: 149049

149049

Parent Item: D206-642-521PHI

D206-642-521PHI

Parent Item Name: Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D2712

Manufactured No

Each

309.0000

Start Qty: 1.00

Required Qty: 1.00

D2712

Set Screw

**

10

PC DAS 28 9-89

Location

Loc Qty

Loc Code

FG	55	
29962	55	
ST009	154	
140532	44	
141690	100	
89929	10	
ST012a	100	
147570	50	
147801	50	

10

DAS 27 9-89

D2934

Manufactured No

Each

58.0000

D2934

Saddle Spacer

**

2

PC DAS 28 9-89

Location

Loc Qty

Loc Code

FG	6	
31929	6	
ST014	52	
141428	12	
147488	40	

2

JUL 27 2016

DAS 27 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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Picklist Print

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Work Order ID: 149049

149049

Parent Item: D206-642-521PHI

D206-642-521PHI

Parent Item Name: Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D3456-1

Manufactured No

Each

87.0000

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Washer

**

PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST037

5

144158

5

ST038A

75

147066

25

147799

50

D2935

Manufactured No

Each

69.0000

D2935

Saddle Spacer

**

PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FG

6

31793

6

ST014

63

146008

33

147574

30

D3457-1

Manufactured No

Each

108.0000

D3457-1

Washer

**

PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FG

10

32409

10

ST037

98

145625

98

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

Tuesday, July 19, 2016 10:17:02 AM

Page 9

Work Order ID: 149049

149049

Parent Item: D206-642-521PHI

D206-642-521PHI

Parent Item Name: Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

AN3C36A

Purchased

No

Each

240.0000

Start Qty: 1.00

Required Qty: 1.00

AN3C36A

Bolt

**

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	47	
101261	4	
122204	2	
m131367	1	
m132169	40	
FP001	80	
m131856	1	
m132381	79	
OVER002	80	
m133916	80	
ST347	33	
m132522	33	

Each

47.0000

**

DAS
28
9-89

AN3C35A

Purchased

No

AN3C35A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	4	
18914	4	
ST347	43	
M132317	18	
M133694	25	

9
3
3

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Tuesday, July 19, 2016 10:17:02 AM

Work Order ID: 149049

149049

Parent Item: D206-642-521PHI

D206-642-521PHI

Parent Item Name: Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

NAS1149C0332R

Purchased

No

Each

3,118.000

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

WASHER

**

24

PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FP001

1686

m135046

1686

GA

141

m133284

141

ST266

1291

m134736

1291

Each

992.0000

**

24

PC DAS 28 9-89

D3672-1

Manufactured

No

D3672-1

Washer, Phenolic

DAS 27 9-89

Location

Loc Qty

Loc Code

FG

10

85222

10

FP001

482

112218

8

134785

474

ST049

500

147077

500

Each

35.0000

**

2

PC DAS 28 9-89

D3396-3

Manufactured

No

D3396-3

Bushings

DAS 27 9-89

Location

Loc Qty

Loc Code

ST034

35

132598

12

147439

23

2

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Picklist Print

Tuesday, July 19, 2016 10:17:02 AM

Work Order ID: 149049

149049

Parent Item: D206-642-521PHI

D206-642-521PHI

Parent Item Name: Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

AN5C35A

Purchased No

Each

61.0000

Start Qty: 1.00

Required Qty: 1.00

AN5C35A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

ST336

61

M129871

61

Each

123.0000

**

AN5C32A

Purchased No

AN5C32A

BOLT

Location

Loc Qty

Loc Code

FG

4

18918

4

over004

100

131650

100

ST336

19

m132102

19

DAS
27
9-89

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

Tuesday, July 19, 2016 10:17:02 AM

Page 12

Work Order ID: 149049

149049

Parent Item: D206-642-521PHI

D206-642-521PHI

Parent Item Name: Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

AN5C34A

Purchased

No

Each

104.0000

Start Qty: 1.00

Required Qty: 1.00

AN5C34A

Bolt

**

PC DAS 28 9-89

Location

Loc Qty

Loc Code

FG	2	
18918	2	
over004	88	
m131855	8	
m131856	8	
m132169	8	
m132381	8	
m132522	8	
m132674	8	
m133332	8	
m133917	8	
m133920	8	
m133921	8	
m134131	8	

ST336

14

m130033

14

Each

162.0000

**

P DAS 28 9-89

MS21043-5

Purchased

No

MS21043-5

Nut

Location

Loc Qty

Loc Code

FG	20	
101418	20	
GA	76	
116548	76	
ST302	66	
m135157	66	

DAS 27 9-89

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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								Lead hand / Supervisor Approval Verification																	
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. Q AND INSTRUCTIONS FOR CONTINUED
AIRWORTHINESS ICA-D206-642 REV. 6 OR LATER APPROVED REVISION

REF. FAA STC: SA00475SE

REF. TCCA STC: SH98-4

REF. EASA STC: EASA.IM.R.S.01320

PURPOSE:

TO ADD D206-642-521/-522 SKIDTUBE INSTALLATIONS WITH WEARPADS ONLY AS
PREFERRED BY SOME CUSTOMERS.

PARTS LIST:

PARTS LIST OF SECTION 4.7 OF IIN-D206-642 REV. Q AND SECTION 32.17 OF ICA-D206-642
REV. 6 IS AMENDED AS SHOWN BELOW TO REFLECT THE ADDITION OF D206-642-521/-522/-
561 CONFIGURATIONS.

ITEM	Qty -521	Qty -522	Qty -561	Part Number	Description
	X			D206-642-521	FLOAT SKIDTUBE INSTALLATION, LH
		X		D206-642-522	FLOAT SKIDTUBE INSTALLATION, RH
	1	1	X	D206-642-561	FLOAT SKIDTUBE
	1	1		D206-648-013	GROUND HANDLING KIT
1			1	D3274-045	SKIDTUBE ASSEMBLY
3			1	D2646	* AFT CAP (1)
4			2	AN3C4A	* BOLT (1)
5A			2	NAS1149C0332R	* WASHER (1)
5B			2	D3672-1	* WASHER (1)
20A			9	D3537-9	* WEARPAD (1)
21A			1	D3537-11	* WEARPAD (1)
26A			40	AN3C4A	* BOLT (1)
26B			40	NAS1149C0332R	* WASHER (1)
26C			40	ALS7-1032-130	* INSERT (1)
34			1	MS27039C4-06	* SCREW (1)
35			1	NAS1149C0463	* WASHER (1)
6	1			D2932-1	SADDLE, FWD OUT, LH
6		1		D2932-2	SADDLE, FWD OUT, RH
7	1			D2933-1	SADDLE, FWD IN, LH
7		1		D2933-2	SADDLE, FWD IN, RH
8	1			D2938-1	SADDLE, AFT OUT, LH
8		1		D2938-2	SADDLE, AFT OUT, RH
9	1			D2939-1	SADDLE, AFT IN, LH
9		1		D2939-2	SADDLE, AFT IN, RH

A	NEW ISSUE	AK	16.05.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AK		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9749	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ADD -521/-522/-561 SKIDTUBES NTS	
DATE	16.05.30	COPYRIGHT © 2016 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	Qty -521	Qty -522	Qty -561	Part Number	Description
	X			D206-642-521	FLOAT SKIDTUBE INSTALLATION, LH
		X		D206-642-522	FLOAT SKIDTUBE INSTALLATION, RH
			X	D206-642-561	FLOAT SKIDTUBE
10	8	8		AN3C41A	BOLT
11	16	16		D2652	BUSHING
12A	8	8		MS21043-3	NUT
12B	16	16		D3672-7	WASHER
13	4	4		AN5C11A (or AN5C12A)	* BOLT (2)
14	4	4		AN5C11A (or AN5C13A)	* BOLT (2)
15A	8	8		NAS1149C0532R	WASHER
15B	8	8		D3672-7	WASHER
16	12	12		AN4C6A	BOLT
17A	24	24		D3672-3	WASHER
17B	24	24		NAS1149C0432R	WASHER
18	12	12		MS21043-4	NUT
37	10	10		D2712	SET SCREW
38	2	2		D2934	SADDLE SPACER
39	2	2		D2935	SADDLE SPACER
50	9	9		AN3C36A	BOLT
51	3	3		AN3C35A	BOLT
52	24	24		NAS1149C0332R	WASHER
53	24	24		D3672-1	WASHER
54	12	12		MS21043-3	NUT
55	2	2		D3396-3	SPACER
56A	1	1		AN5C35A	BOLT
56B	1	1		AN5C15A	BOLT
60	2	2		AN5C32A	BOLT
61	2	2		AN5C34A	BOLT
62	4	4		MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-045 ASSEMBLY ABOVE

(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

DESIGN	AK	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AK		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9749	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ADD -521/-522/-561 SKIDTUBES NTS	
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INSTALLATION:**REFERENCE ONLY**

INSTALL D206-642-521/-522 SKIDTUBE INSTALLATIONS PER SECTION 3.3 OF IIN-D206-642 REV. Q.

WEIGHT AND BALANCE:

THE WEIGHT AND BALANCE TABLES IN SECTION 5.2.1/5.2.2 OF IIN-D206-642 REV. Q AND SECTION 3.10.2 OF ICA-D206-642 REV. 6 ARE AMENDED TO ADD D206-642-521/-522 CONFIGURATIONS AS SHOWN BELOW:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-642-521 206L/L1/L3/L4 HIGH FLOAT, LH	36.4 lb 16.5 kg	104.1 in 2.64 m	3789 in lb 43.6 m kg	-43.0 in -1.09 m	-1565 in lb -18.0 m kg
D206-642-522 206L/L1/L3/L4 HIGH FLOAT, RH	36.4 lb 16.5 kg	104.1 in 2.64 m	3789 in lb 43.6 m kg	43.0 in 1.09 m	1565 in lb 18.0 m kg
D206-642-521 407 HIGH FLOAT, LH	36.4 lb 16.5 kg	104.1 in 2.64 m	3789 in lb 43.6 m kg	-47.0 in -1.19 m	-1711 in lb -19.6 m kg
D206-642-522 407 HIGH FLOAT, RH	36.4 lb 16.5 kg	104.1 in 2.64 m	3789 in lb 43.6 m kg	47.0 in 1.19 m	1711 in lb 19.6 m kg

MAINTENANCE:

THE NEW D206-642-521/-522/-561 FLOAT SKIDTUBES SHOULD BE MAINTAINED PER ICA-D206-642 REV. 6, OR LATER APPROVED REVISION.

DESIGN	AK	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AK		
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9749	SHEET 3 OF 3
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	ADD -521/-522/-561 SKIDTUBES	NTS
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Work Order ID 149049

Tuesday, July 19, 2016 10:16:45 AM

149049

PRELIMINARY ISSUE

Page 1

Item ID: D206-642-521PHI

Accept

N9000040100

Setup Start *NS1*

Revision ID: PRELIM



Stop *NS2*

Item Name: Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/27/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 19 2016 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	Q								
100	Document Control	<u>DAS 9-89</u> 0.00					<u>DAS 21 9-89</u>	<u>JUL 27 2016</u>	
100	DOCUMENT CONTROL								
DC	Memo	0.00			<u>DAS 21 9-89</u>				
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-511								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

CHG 001
see attachment

Change Record

PAGE 1 OF 1

Part Number: D206-642-521PHI/-522PHI

Description: FLOAT SKIDTUBE , LH/RH

[illegible]